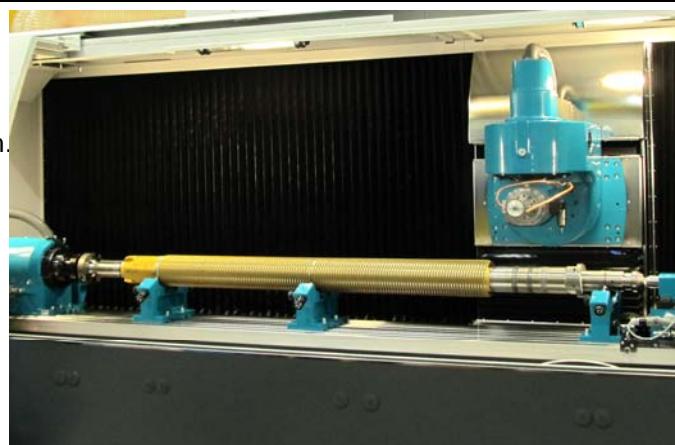


Cylindrical broach Ø170 z154

A14-020

The resharpening process of this example tool contains regrinding of the groove with total removal amount of 0.1mm. The division can be reproduced either according a fixed definition in Quinto or based on the probed data.



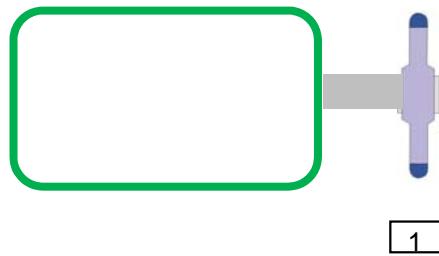
1. Cycletime for Resharpening

Workpiece:			
Diameter 170mm; Nr. of teeth 154			
Material HSS			
Operations			
Feed [mm/Min]	3000	1	
Power [kW]		3	
Cutting feed [m/s]		30	
Used wheels			1
Grinding time [min]	3	150	
Total cycle time	153 min		

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1 14F1 Ø80 B91



3. Machine and Software Requirements

Machines: 6 axes CNC grinders : Corvus BBA Coolant: Synthetic Oil, pressure 6 bar

Control: Fanuc 31i

Software: Quinto 5

Accessories: Dog and driver, Hydraulic tailstock, Support

Responsible engineer: SIW, 12.12.2013

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TECHNOLOGY
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